

Date: Wednesday, 27/05/2009 7:53:52 AM  
 User: Melanie Fauteux

# Process Sheet

|                       |                                |                  |                              |
|-----------------------|--------------------------------|------------------|------------------------------|
| Customer              | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name     | : D105-674-011               |
| Job Number            | : 48212                        |                  |                              |
| Estimate Number       | : 10804                        |                  |                              |
| P.O. Number           | :                              | Part Number      | : D105674011                 |
| This Issue            | : 27/05/2009 S.O. No. :        | Drawing Number   | : R09-060                    |
| Prsht Rev.            | : NC                           | Project Number   | :                            |
| First Issue           | : / / Type : SKIDTUBES         | Drawing Revision | :                            |
| Previous Run          | : 00015                        | Material         | :                            |
| Written By            | : <u>26505-27</u>              | Due Date         | : 02/06/2009 Qty: 1 Um: Each |
| Checked & Approved By | : <u>MF 09-05-27</u>           |                  |                              |
| Comment               | :                              |                  |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |            |          |
|-----|------------|----------|
| 1.0 | D105674011 | Skidtube |
|-----|------------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Skidtube  
 Original B41330 @ CHG002

Tube is in good condition

|     |     |                              |
|-----|-----|------------------------------|
| 2.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

801/05/27 → New labels and paperwork necessary with the new batch # @ CHG002 JU09-05-27 ①

Re-identify the parts using the original W/O attached as reference, re-package and return to stock.

Location: \_\_\_\_\_

164/06/28 ①

|     |      |                              |
|-----|------|------------------------------|
| 4.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

09/06/15 MF

Job Completion



MF  
09-06-12

Date: Monday, 18/08/2008 3:39:00 PM  
 User: Julie Lecocq

## Process Sheet

|                       |                                       |                  |                              |
|-----------------------|---------------------------------------|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : BO 105 SKIDTUBE ASSEMBLY   |
| Job Number            | : 41330                               |                  |                              |
| Estimate Number       | : 10119                               |                  |                              |
| P.O. Number           | :                                     | Part Number      | : D105674011                 |
| This Issue            | : 18/08/2008 S.O. No. :               | Drawing Number   | : D2966 REV A2               |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                        |
| First Issue           | : // Type : SKIDTUBES                 | Drawing Revision | : A2                         |
| Previous Run          | :                                     | Material         | :                            |
| Written By            | :                                     | Due Date         | : 15/09/2008 Qty: 1 Um: Each |
| Checked & Approved By | <u>JLD 08.8.18</u>                    |                  |                              |
| Comment               | : Est Rev:A 04.07.07 New Issue KJ/JLM |                  |                              |

## Additional Product

Job Number:



REFERENCE ONLY

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.9.16



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP d105-674-0116 CHG002

2.0 D2962125 Outer Tube Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-125 Extrusion 17532

KT 08-08-26

3.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

KT 08-08-26

4.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

KT 08-08-27

5.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185-1G

KT 08-08-27

## Process Sheet

R001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

41330

Part Number: D105674011

REFERENCE ONLY



Eq. #:

Machine Or Operation:

Description:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expiry date:

3-Wing Walk as per Dwg D2966 and QSI 005 4.4

Batch:

31.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

32.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

\*\*\*\*\*ENSURE INSERTS ARE AT LOCATION (6) AS PER DWG D2966\*\*\*\*\*

33.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

34.0

D2972

Bushing

Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

6 D2972 Bushing

14163

35.0

D2974

Packer

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2974 Packer

31249

36.0

D2975

Wearshoe

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2975 Wearplate

34234

## Process Sheet

AR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

41330

Part Number: D105674011

REFERENCE ONLY



Seq. #:

Machine Or Operation:

Description :

37.0

AN451A

Bolt

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN4-51A Bolt

M108376

38.0

AN960JD10L

Washer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10L Washer

M108376

M105793

39.0

MS21042L4

Nut

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 MS21042L4

Nut

M107499

40.0

MS27039108

Screw

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS27039-1-08 Screw

M109001

41.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

42.0

PACKAGING 1

PACKAGING RESOURCE #1

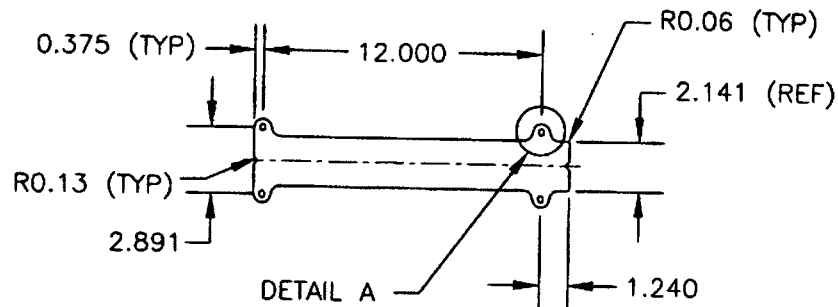
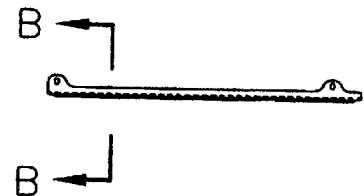
Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D105-674-011G

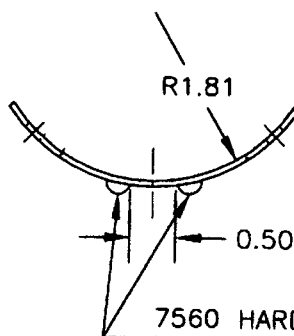
Location:

**DART**

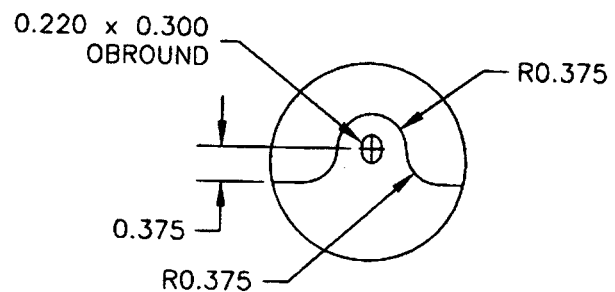
|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | DART AEROSPACE USA, INC.<br>BELLEVUE, WA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2975                     | REV. A<br>SHEET 1 OF 1 |
| DATE<br>00.03.10              |                                | TITLE<br>WEARPLATE                       | SCALE<br>1:8           |
| A                             | 00.03.10                       | NEW ISSUE                                |                        |

FLAT PATTERNBENDING DETAIL

REFERENCE ONLY

SECTION B-B  
SCALE 2:5

7560 HARDCOAT WELDS TO  
WITHIN 0.25 OF WEARSHOE  
ENDS 0.063 TO 0.125 THICK

DETAIL A  
SCALE 2:5

48212

**RELEASED**  
00.05.11 *[Signature]*

BREAK ALL SHARP EDGES 0.010 TO 0.020  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL  
16 GAUGE (0.063 THICK)  
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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